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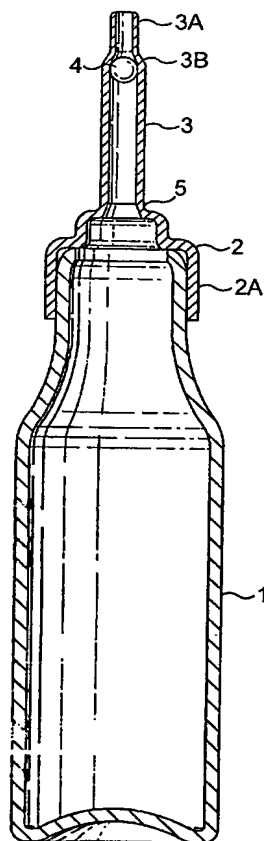
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(54) Title: **GAS CAPSULES AND METHOD OF FILLING THEM**



(57) Abstract: A gas capsule comprises a hollow body portion (1) and a cap (2) including a stem (3) providing a filling orifice (3A). Prior to assembly of the body portion (1) and the cap (2) a stopper member (4) is inserted loosely within the capsule. During filling of the capsule with gas, the stopper member (4) is located within the body of the capsule and, prior to release of the gas pressure at the orifice (3A) of the capsule, the stopper member is moved to obstruct the path of gas from the capsule, for example by inverting the capsule so that the stopper member falls under gravity into a position between the body of the capsule (1) and the filling orifice (3A). The gas pressure is then released so that the stopper member (4) is forced into the stem (3) under the pressure of the gas to form a gas tight seal closing the orifice (3A). The orifice (3A) may then be welded to form a permanent closure.



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